

*mul*



Dart Aerospace Ltd.  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada  
  
Tel (613) 632-5200  
Fax 613 632-5246

**D2600-3-BENT-LH**  
**Job Sheet 192363**



**Part No:** D2600-3-BENT-LH      **Job Qty:** 10 pcs  
**Part Name:** Extrusion Bent LH  
  
**Part Weight:** 0 lbs      **Status:** New      **Priority:** Medium  
**Job Created:** 3/21/19      **Job Tracking No:**  
**Due Date:** 4/15/19      **Created By:** Marie Lajeunesse  
**Type:** SOLD      **Description:**  
**Note:** DWG D2750 REV G SHEET 4, D2600 REV E SHEET 2 IPP REV:A 14.01.14 NEW ISSUE DD VERF:JLM  
**Ship Via:**

**Bill of Materials**

**Job Routing**

| Op No | Operation                   | Qty    | Start Date | Due Date | Standard  |         | Workcenter/Supplier    |           | Sign-off    |
|-------|-----------------------------|--------|------------|----------|-----------|---------|------------------------|-----------|-------------|
|       |                             |        |            |          | Setup Hrs | Run Hrs | Workcenter / Supplier  | Lead Time |             |
| 100   | Skid tubes - Bend - 1       | 10 pcs | 4/15/19    | 4/15/19  | 0.20      | 3.22    | Skid tubes - Bend      |           | <i>M/Ls</i> |
| 110   | QC 5                        | 10 pcs | 4/15/19    | 4/15/19  | 0.00      | 0.00    | QC 5 - 10              |           |             |
|       |                             |        |            |          |           |         | QC 5 - 12              |           |             |
|       |                             |        |            |          |           |         | QC 5 - 17              |           |             |
|       |                             |        |            |          |           |         | QC 5 - 18              |           | <i>BE</i>   |
|       |                             |        |            |          |           |         | QC 5 - 19              |           |             |
|       |                             |        |            |          |           |         | QC 5 - 22              |           |             |
|       |                             |        |            |          |           |         | QC 5 - 24              |           |             |
|       |                             |        |            |          |           |         | QC 5 - 3               |           |             |
|       |                             |        |            |          |           |         | QC 5 - 43              |           |             |
|       |                             |        |            |          |           |         | QC 5 - 49              |           |             |
|       |                             |        |            |          |           |         | QC 5 - 51              |           |             |
|       |                             |        |            |          |           |         | QC 5 - 58              |           |             |
|       |                             |        |            |          |           |         | QC 5 - 68              |           |             |
|       |                             |        |            |          |           |         | QC 5 - 9               |           |             |
|       |                             |        |            |          |           |         | QC 5 - 50              |           |             |
|       |                             |        |            |          |           |         | QC 5 - 30              |           |             |
|       |                             |        |            |          |           |         | QC 5 - 40              |           |             |
| 120   | Packaging 3-1 - Stock - B4B | 10 pcs | 4/15/19    | 4/15/19  | 0.00      | 0.00    | Packaging 3 - 1 - B4B  |           |             |
|       |                             |        |            |          |           |         | Packaging 3 - 2 - B4B  |           |             |
|       |                             |        |            |          |           |         | Packaging 3 - 3 - B4B  |           |             |
|       |                             |        |            |          |           |         | Packaging 3 - 4 - B4B  |           |             |
|       |                             |        |            |          |           |         | Packaging 3 - 5 - B4B  |           |             |
|       |                             |        |            |          |           |         | Packaging 3 - 6 - B4B  |           |             |
|       |                             |        |            |          |           |         | Packaging 3 - 7 - B4B  |           |             |
|       |                             |        |            |          |           |         | Packaging 3 - 8 - B4B  |           |             |
|       |                             |        |            |          |           |         | Packaging 3 - 9 - B4B  |           |             |
|       |                             |        |            |          |           |         | Packaging 3 - 10 - B4B |           |             |
|       |                             |        |            |          |           |         | Packaging 3 - 11 - B4B |           |             |
|       |                             |        |            |          |           |         | Packaging 3 - 12 - B4B |           |             |
|       |                             |        |            |          |           |         | Packaging 3 - 13 - B4B |           |             |



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Container No: S166439



Part: D2600-3-BENT-LH  
Job No: 192363  
Serial No/Batch: S166439  
Revision:  
Inspector:  
Exp Date:  
Instructions:

Date: 03/26/19

|                |        |         |           |  |                        |      |
|----------------|--------|---------|-----------|--|------------------------|------|
|                |        |         |           |  | Packaging 3 - 14 - B4B |      |
|                |        |         |           |  | Packaging 3 - 15 - B4B |      |
|                |        |         |           |  | Packaging 3 - 16 - B4B |      |
|                |        |         |           |  | Packaging 3 - 17 - B4B |      |
|                |        |         |           |  | Packaging 3 - 18 - B4B |      |
|                |        |         |           |  | Packaging 3 - 19 - B4B |      |
|                |        |         |           |  | Packaging 3 - 20 - B4B |      |
|                |        |         |           |  | Packaging 3 - 21 - B4B |      |
|                |        |         |           |  | Packaging 3 - 22 - B4B |      |
|                |        |         |           |  | Packaging 3 - 23 - B4B |      |
|                |        |         |           |  | Packaging 3 - 24 - B4B |      |
|                |        |         |           |  | Packaging 3 - 25 - B4B |      |
|                |        |         |           |  | Packaging 3 - 26 - B4B | BE   |
|                |        |         |           |  | Packaging 3 - 27 - B4B |      |
|                |        |         |           |  | Packaging 3 - 28 - B4B |      |
|                |        |         |           |  | Packaging 3 - 29 - B4B |      |
|                |        |         |           |  | Packaging 3 - 30 - B4B |      |
|                |        |         |           |  | Packaging 3 - 31 - B4B |      |
|                |        |         |           |  | Packaging 3 - 32 - B4B |      |
|                |        |         |           |  | Packaging 3 - 33 - B4B |      |
|                |        |         |           |  | Packaging 3 - 34 - B4B |      |
|                |        |         |           |  | Packaging 3 - 35 - B4B |      |
|                |        |         |           |  | Packaging 3 - 36 - B4B |      |
| 130 QC 21 - SA | 10 pcs | 4/15/19 | 0.00 0.00 |  | QC 21 - SA - 21        | DAQ  |
|                |        |         |           |  | QC 21 - SA - 70        | 21   |
|                |        |         |           |  | QC 21 - SA - 53        | 3-81 |

Part Op 100 - (CNC Delta 100 Bender) Pick qty 1 D2600-3-130 extrusion 1-Deburr one end of extrusion 2-Bend using CNC  
Descriptions: bending machine as per program 2750.C and Folio 14 use bending aid DT9635 3- cut fwd end of tube as per dwg D2750  
4- cut aft end of tube as per dwg D2750  
110 - (QC5- Inspect part completeness to step on W/O)  
120 - (Identify as per dwg & Stock Location: LG002) LOCATION : LG002  
130 - (QC21- Final Inspection - Work Order Release)

| Job BOM     |                        |               |                          |           |
|-------------|------------------------|---------------|--------------------------|-----------|
| Part / Item | Component Name         | Quantity      | Operation                | Container |
| D2600-3-130 | Extrusion Round 3" 350 | 10 pcs (1 ea) | 100-Skidtubes - Bend - 1 | S/24531   |

| Job Allocations          |                |          |           |           |
|--------------------------|----------------|----------|-----------|-----------|
| Operation                | Component Part | Required | Inventory | Allocated |
| 100-Skidtubes - Bend - 1 | D2600-3-130    | 10       | 125       | 0         |

| Part Specifications                |  |
|------------------------------------|--|
| Specifications could not be found. |  |

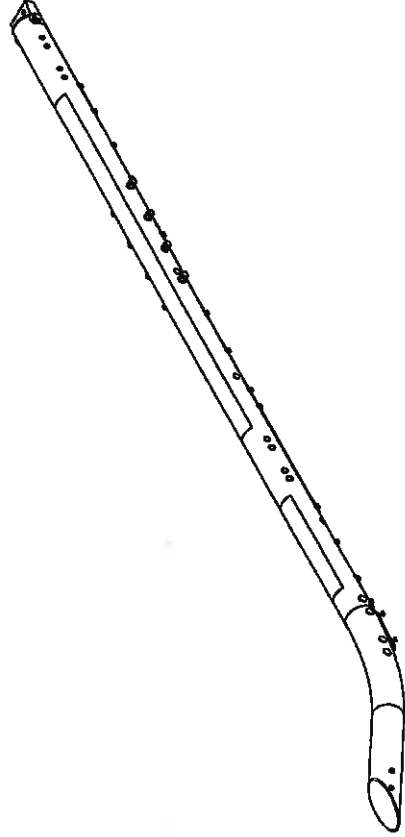


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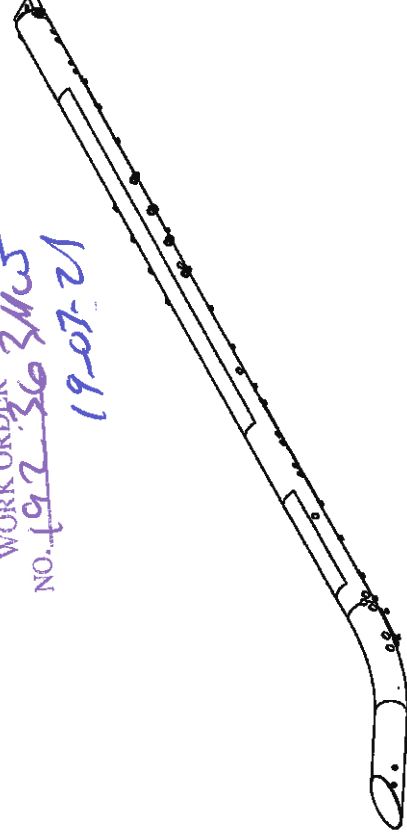
WORK ORDER

NO. 192-363405

19-07-21



D2750-041 350 SKIDTUBE ASSEMBLY, LH

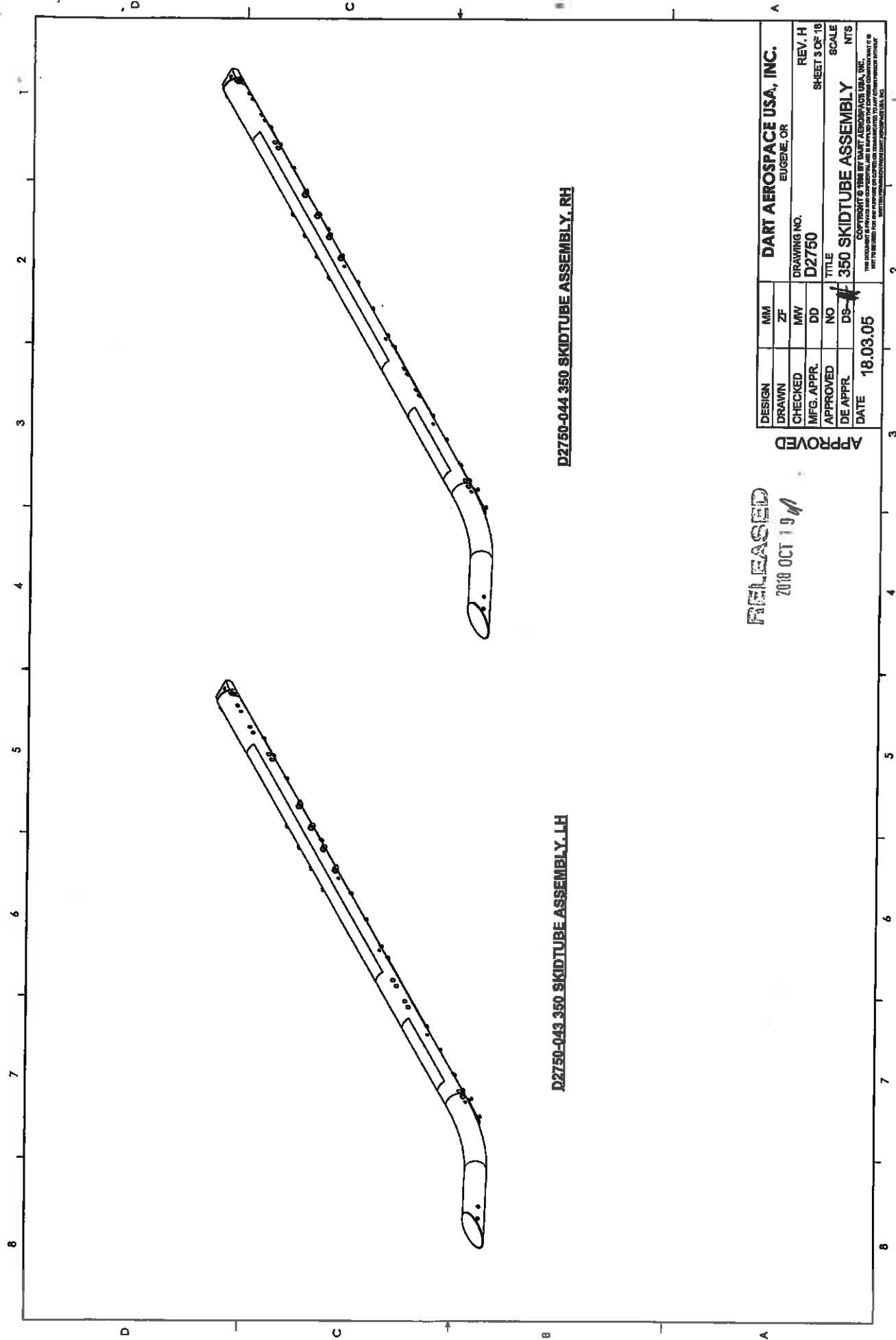


D2750-042 350 SKIDTUBE ASSEMBLY, RH

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|            |          |                          |               |
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| MFG. APPR. | DD       | D2750                    | SHEET 2 OF 18 |
| APPROVED   | NO       | TITLE                    | SCALE         |
| DE APPR.   | DS       | 350 SKIDTUBE ASSEMBLY    | NTS           |
| DATE       | 18.03.05 |                          |               |

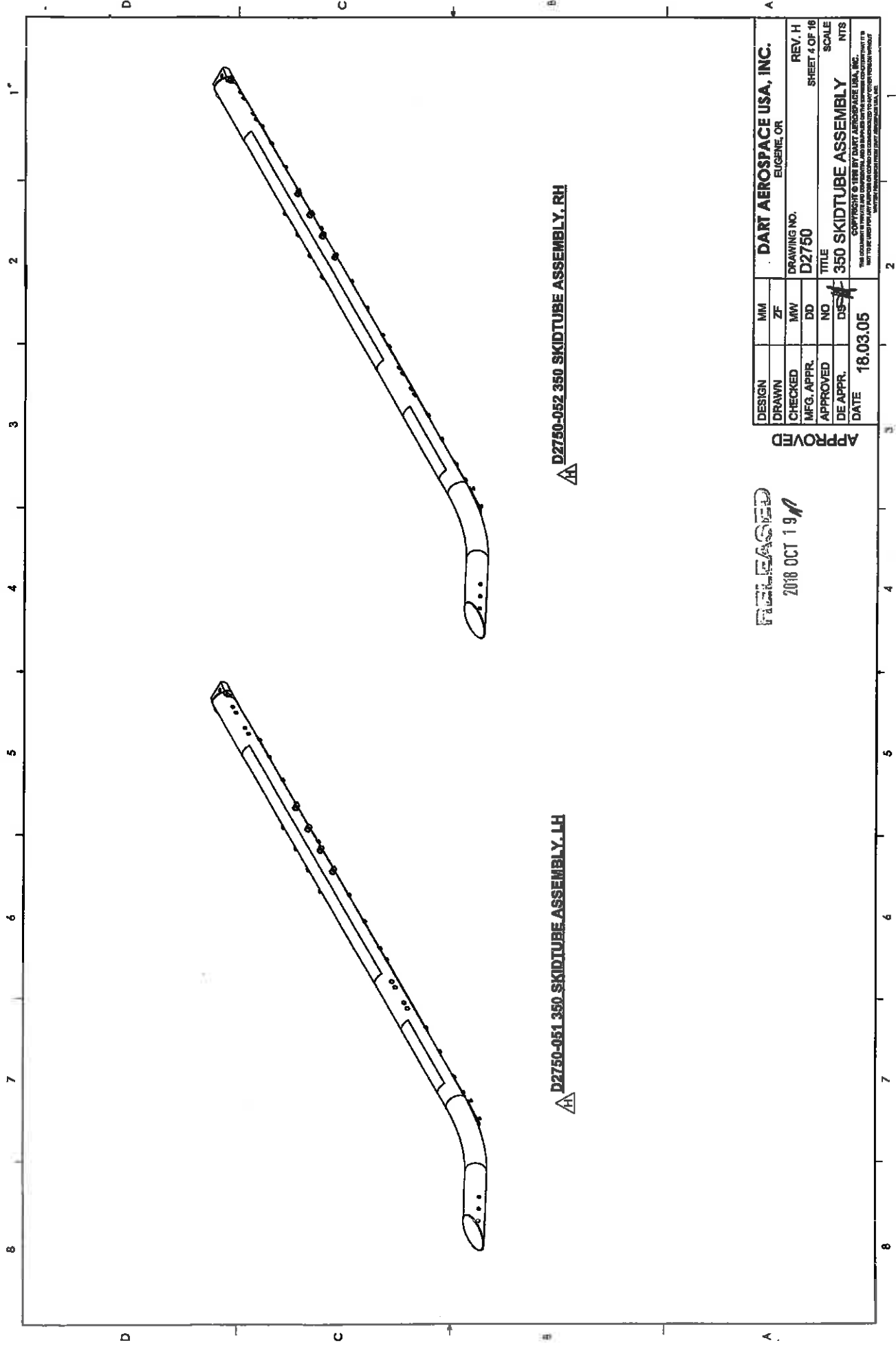
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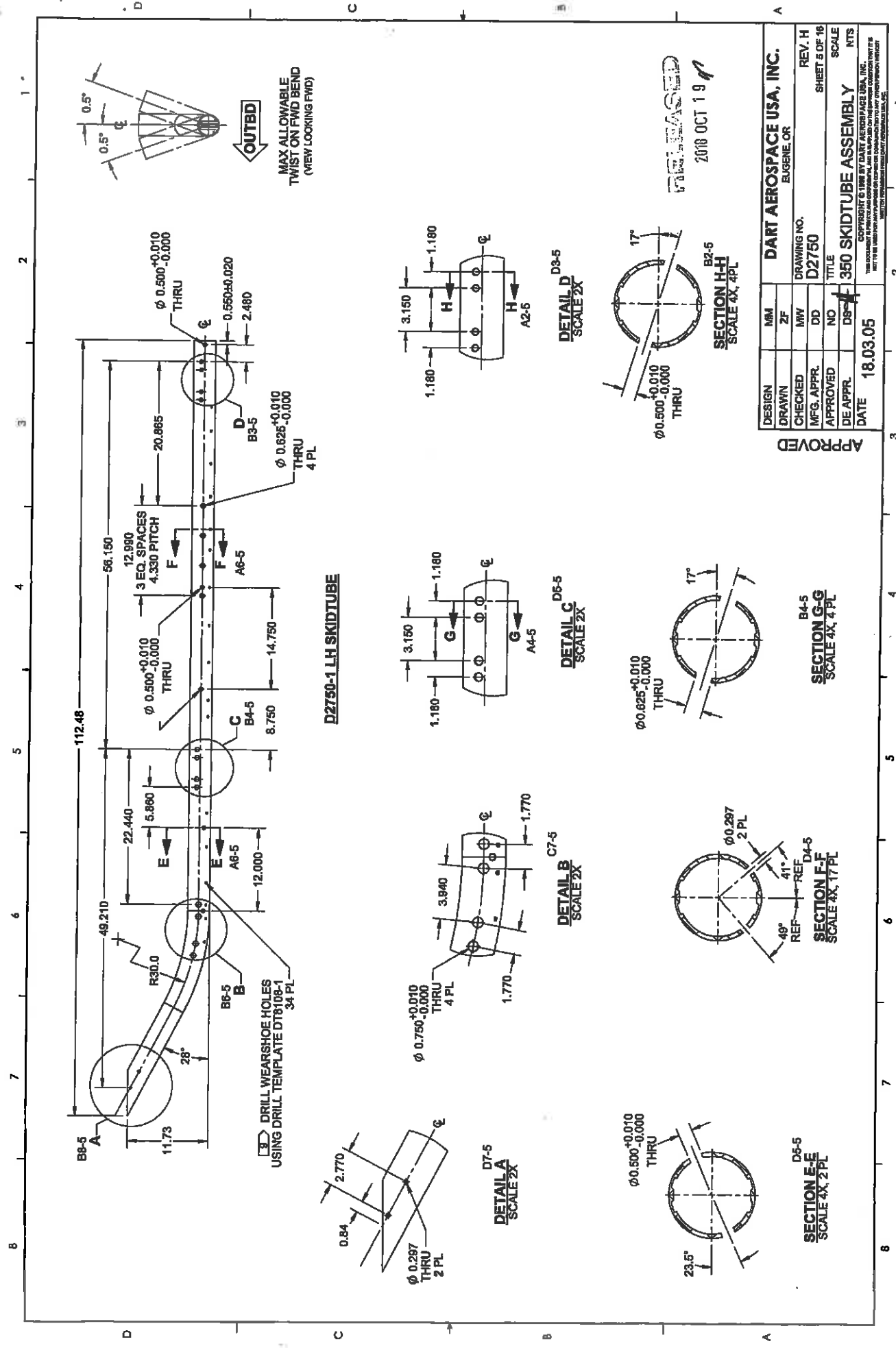


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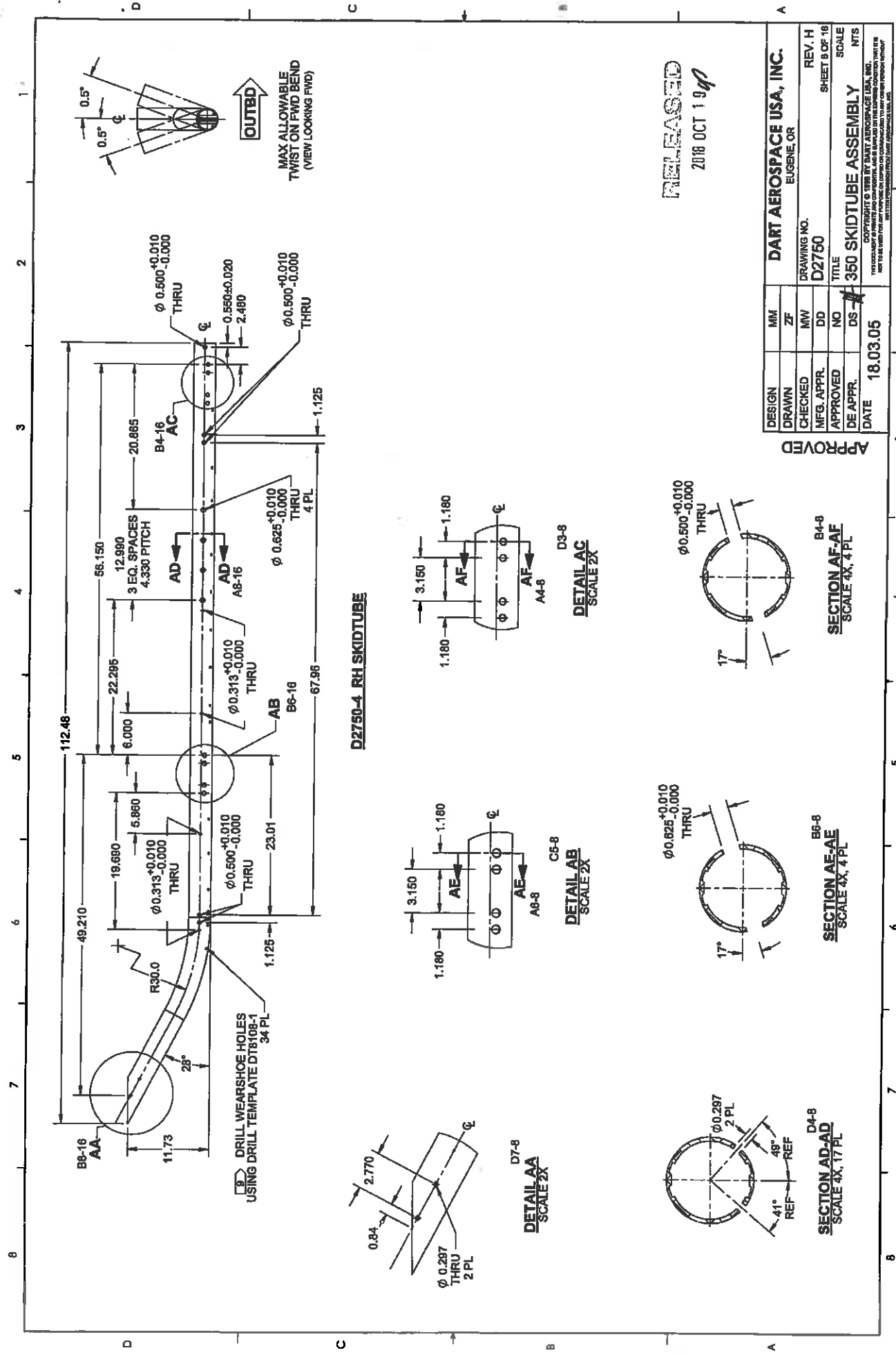
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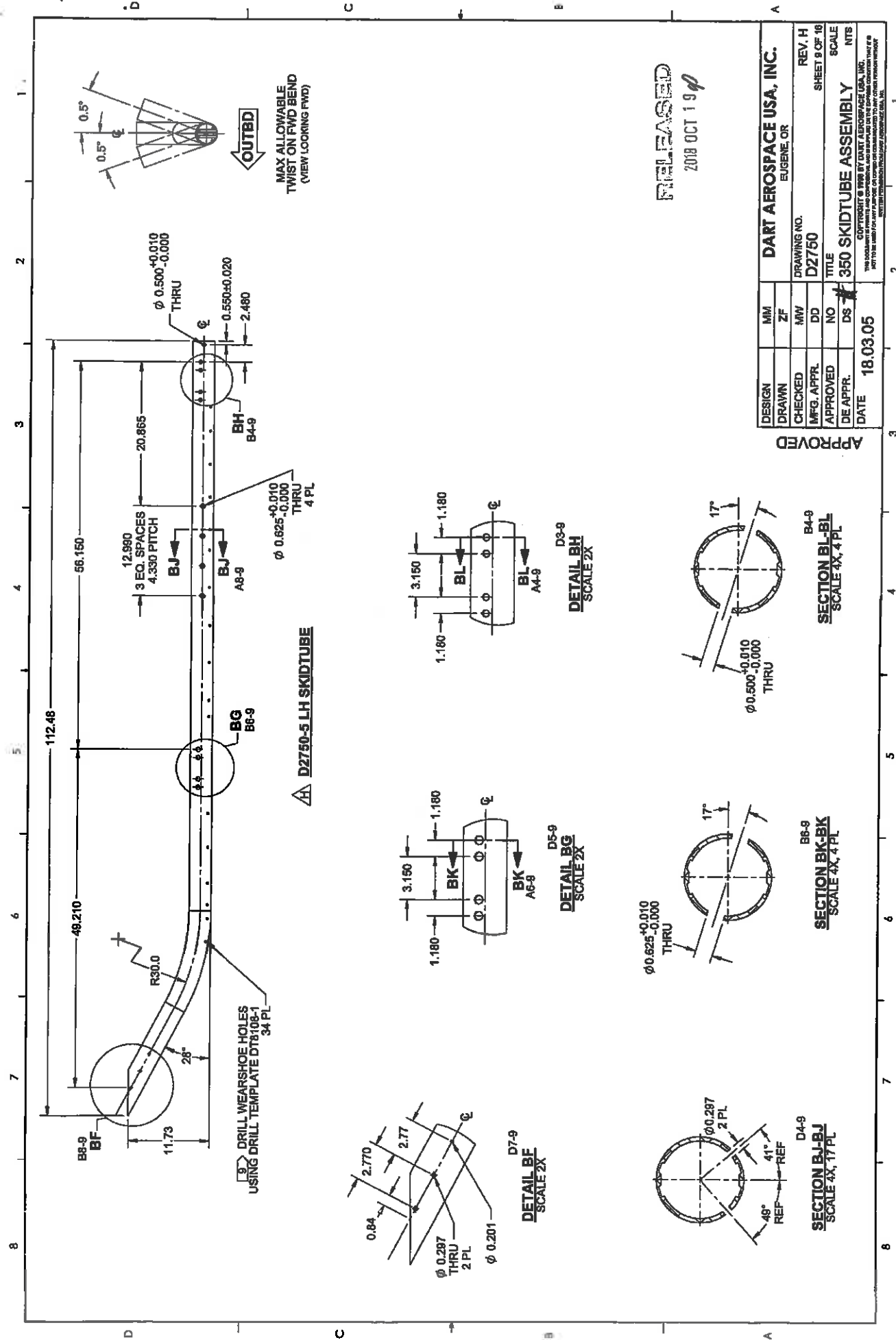




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| DRAWN      | ZF       |                                                                                                                                                                                                                           |
| CHECKED    | MW       |                                                                                                                                                                                                                           |
| MFG. APPR. | DD       |                                                                                                                                                                                                                           |
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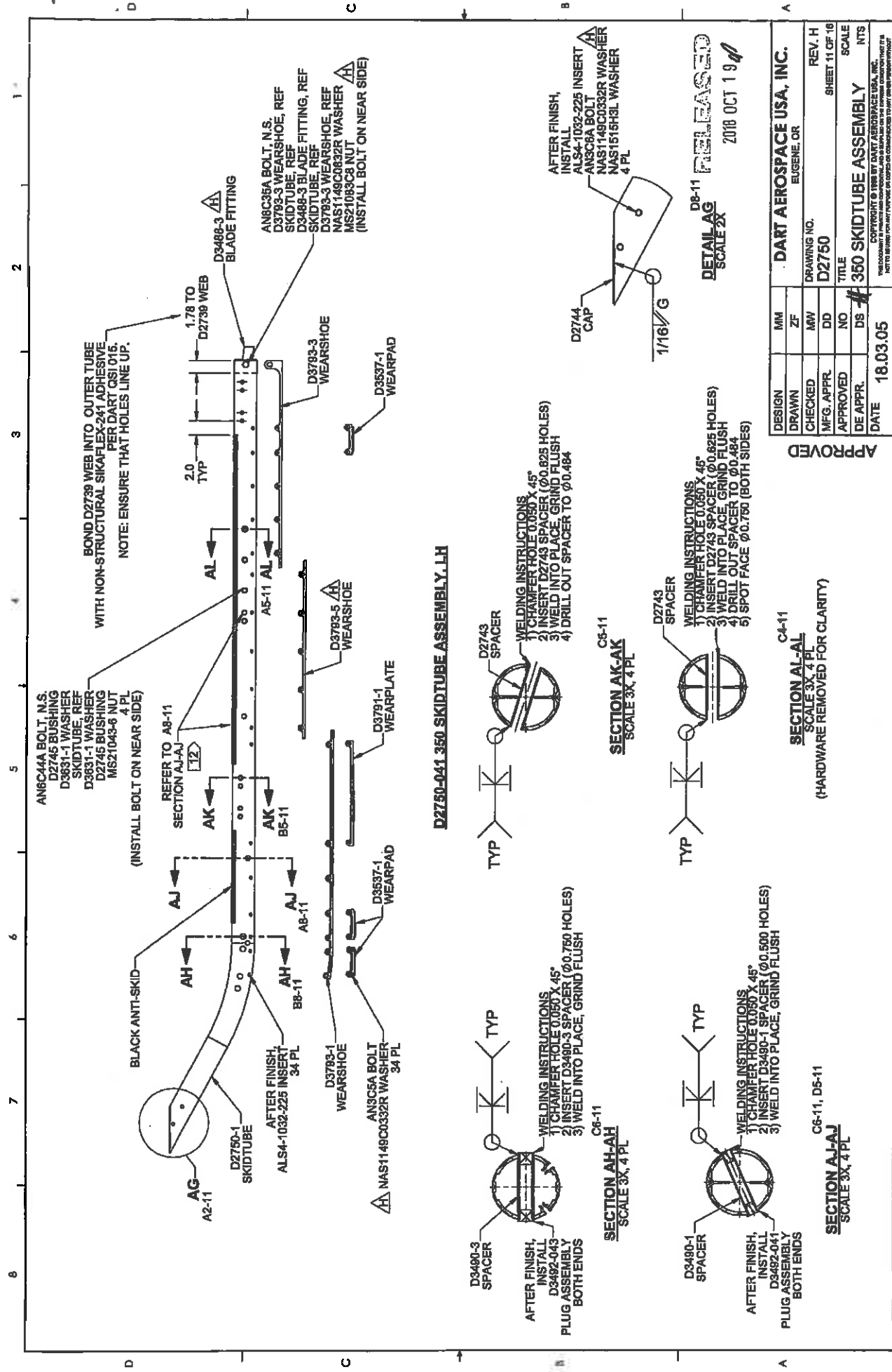


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| MFG. APPL | DD       | REV. H                   |
| APPROVED  | NO       | SHEET 9 OF 16            |
| DATE      | DS       | TITLE                    |
| 18.03.05  | 18.03.05 | 350 SKIDTUBE ASSEMBLY    |
|           |          | SCALE                    |
|           |          | NTS                      |

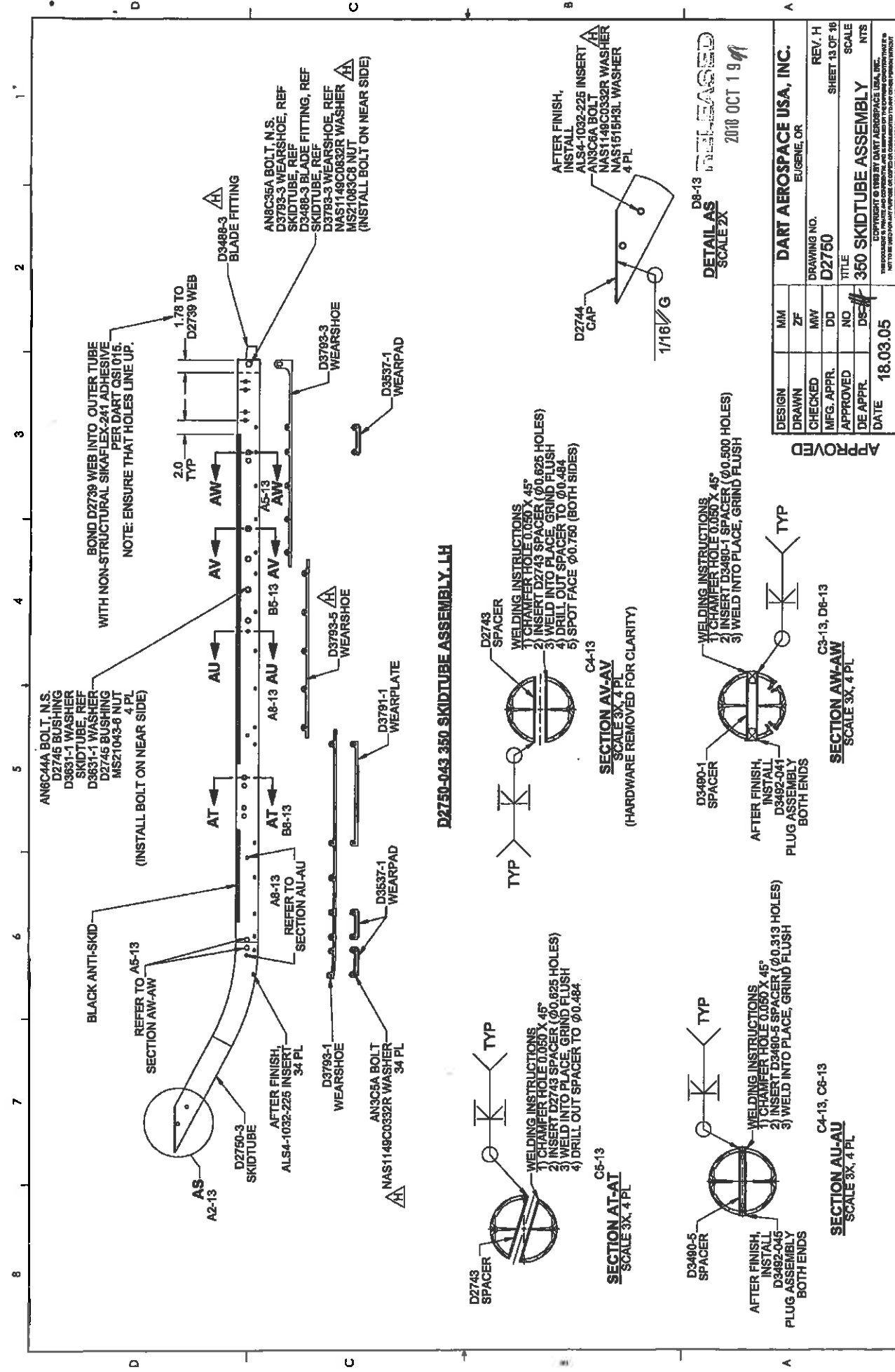
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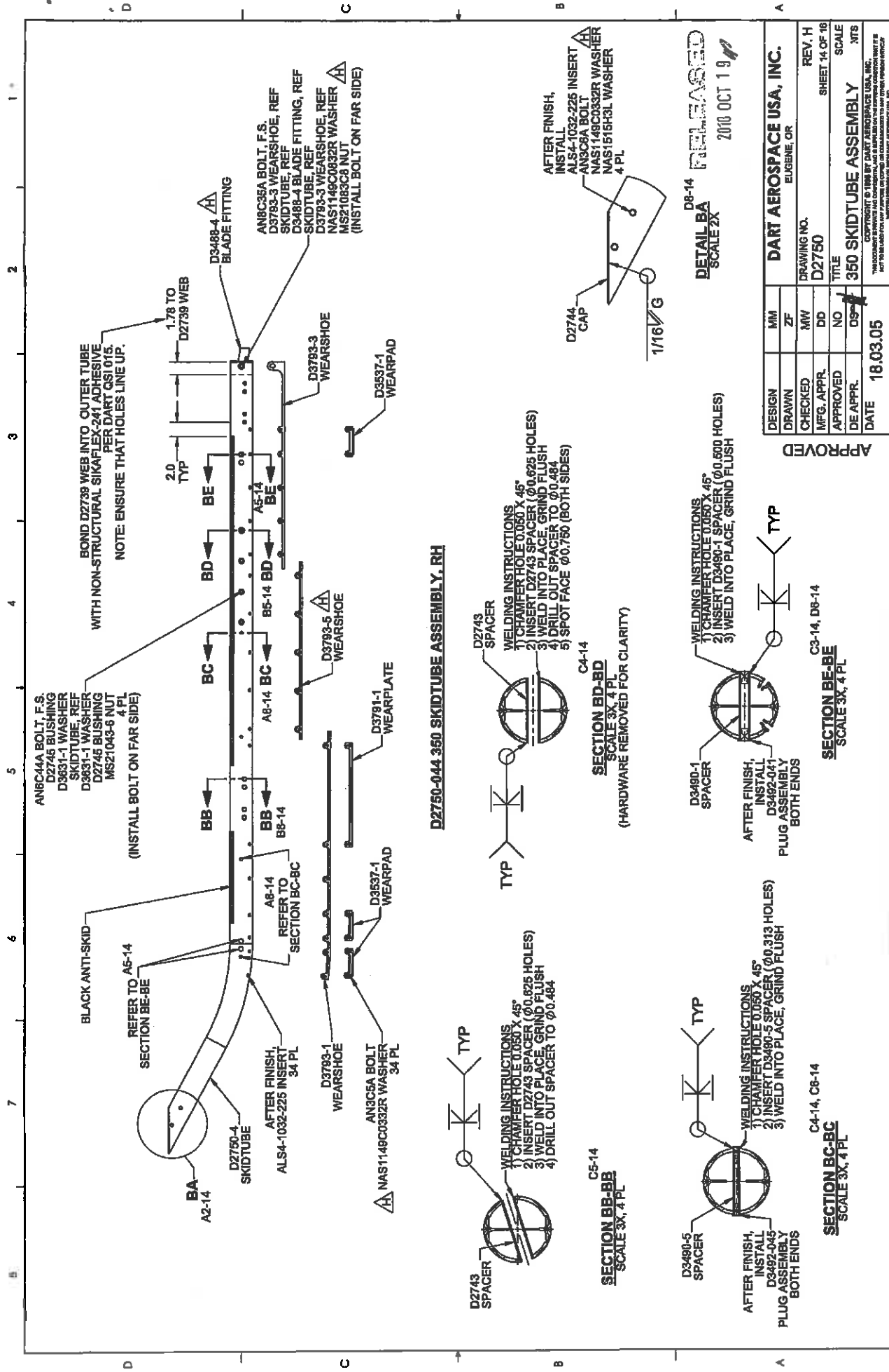




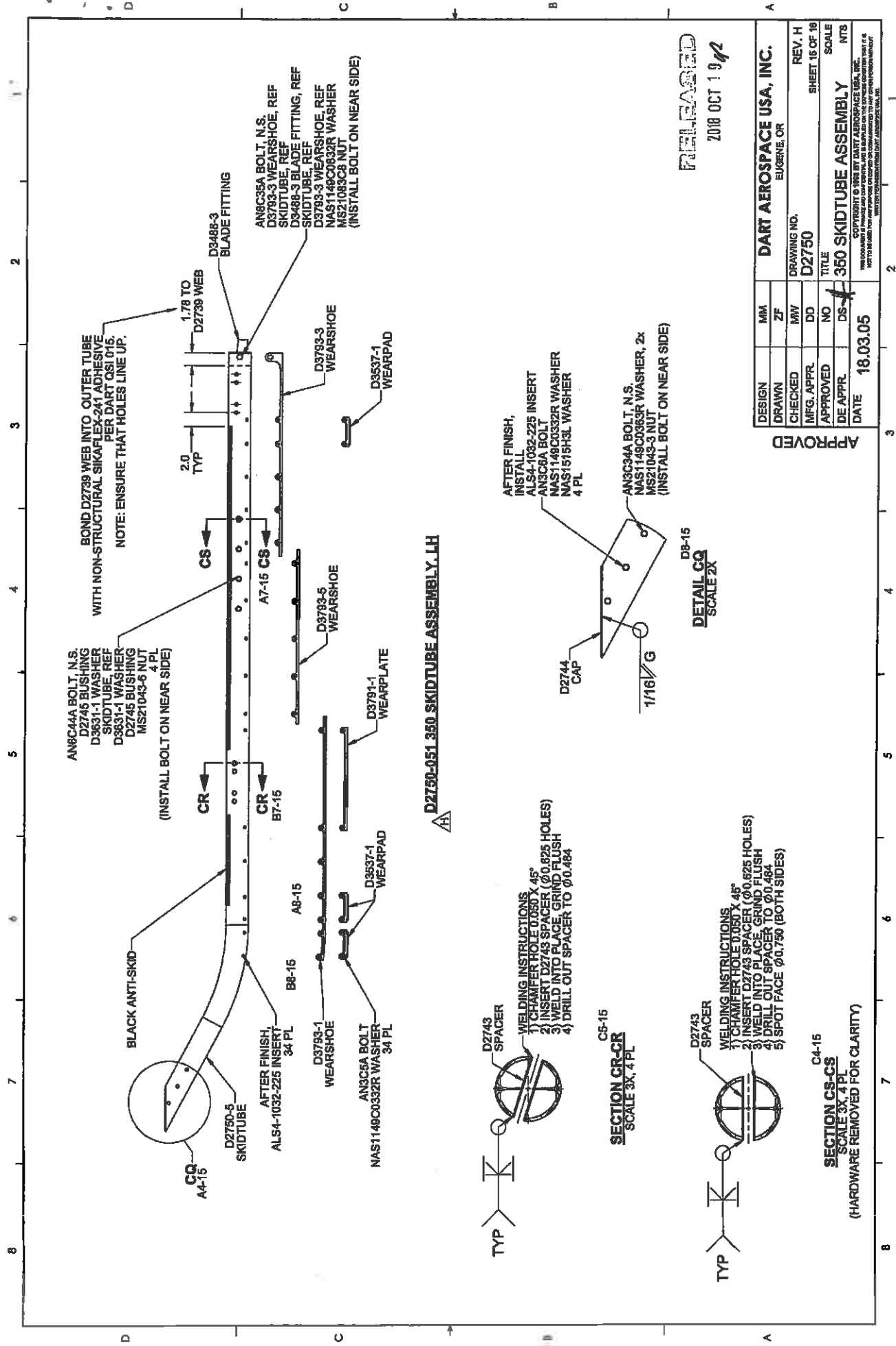
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| MFG. APPR. | DD       | D2750                                                                                                                                                                                                                                                                                                                 | SHEET 11 OF 16 |
| APPROVED   | NO       | TITLE                                                                                                                                                                                                                                                                                                                 | SCALE          |
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mlb  
20 jan 2019

Entered: \_\_\_\_\_ Date: \_\_\_\_\_

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. 19-7221

Route update only



| Job: 192363                                                                                                                                                                                                                                                                                                                                                               |                 | DISPOSITION                                                                |  | DEPARTMENT/PROCESS                                                                                                                                                                                                                                                                                  |  |                                      |  | Route update only                                                                                                                                                                                                                                                                                      |  |                                                 |  |                                                                                                                                                                                                                                                             |  |  |  |
|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------------|----------------------------------------------------------------------------|--|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|--------------------------------------|--|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|-------------------------------------------------|--|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|--|--|
| Part No. D2600-3-BENT-LH                                                                                                                                                                                                                                                                                                                                                  |                 | Rework<br>Scrap<br>Use-as-is <input checked="" type="checkbox"/>           |  | Skid-tube<br>Machining <input checked="" type="checkbox"/><br>Large Fab                                                                                                                                                                                                                             |  | Cross tube<br>Small Fab<br>Finishing |  | Eng. (Non-AW)<br>Prod. Eng. Coord.<br>Rec/Store/Packaging                                                                                                                                                                                                                                              |  | Engineering<br>Water Jet<br>Supplier<br>Quality |  |                                                                                                                                                                                                                                                             |  |  |  |
| Date: 19/3/27                                                                                                                                                                                                                                                                                                                                                             | Sequence #: 110 | QTY Affected:                                                              |  | MRB (QSI042)                                                                                                                                                                                                                                                                                        |  |                                      |  |                                                                                                                                                                                                                                                                                                        |  |                                                 |  |                                                                                                                                                                                                                                                             |  |  |  |
| Description Work Order Deviation                                                                                                                                                                                                                                                                                                                                          |                 | Disposition                                                                |  |                                                                                                                                                                                                                                                                                                     |  |                                      |  |                                                                                                                                                                                                                                                                                                        |  |                                                 |  |                                                                                                                                                                                                                                                             |  |  |  |
| Tube height is +0.08 over nominal after bending/cutting.                                                                                                                                                                                                                                                                                                                  |                 | Acceptable. Length is in tolerance. Unlikely to cause fit issue with step. |  |                                                                                                                                                                                                                                                                                                     |  |                                      |  |                                                                                                                                                                                                                                                                                                        |  |                                                 |  |                                                                                                                                                                                                                                                             |  |  |  |
| Root Cause                                                                                                                                                                                                                                                                                                                                                                |                 | Completed By: <i>U/19/3/27</i>                                             |  |                                                                                                                                                                                                                                                                                                     |  |                                      |  |                                                                                                                                                                                                                                                                                                        |  |                                                 |  |                                                                                                                                                                                                                                                             |  |  |  |
| Operator <input checked="" type="checkbox"/><br>Manufacturing Process <input type="checkbox"/><br>Equip/Tooling <input type="checkbox"/><br>Handling/Preservation <input type="checkbox"/><br>Material <input type="checkbox"/><br>Product Improvement <input type="checkbox"/><br>Process Improvement <input type="checkbox"/><br>Human Factors <input type="checkbox"/> |                 | Lead hand / Supervisor: <i>TW</i><br>19-03-24                              |  |                                                                                                                                                                                                                                                                                                     |  |                                      |  |                                                                                                                                                                                                                                                                                                        |  |                                                 |  |                                                                                                                                                                                                                                                             |  |  |  |
|                                                                                                                                                                                                                                                                                                                                                                           |                 | QC / QA Coordinator: <i>DAS</i><br>68<br>9-89<br>MAR 27 2019               |  |                                                                                                                                                                                                                                                                                                     |  |                                      |  |                                                                                                                                                                                                                                                                                                        |  |                                                 |  |                                                                                                                                                                                                                                                             |  |  |  |
| FAULT CATEGORY                                                                                                                                                                                                                                                                                                                                                            |                 |                                                                            |  |                                                                                                                                                                                                                                                                                                     |  |                                      |  |                                                                                                                                                                                                                                                                                                        |  |                                                 |  |                                                                                                                                                                                                                                                             |  |  |  |
| Pressure/Forced Bending <input checked="" type="checkbox"/><br>Crushing <input type="checkbox"/><br>Cracks <input type="checkbox"/><br>Crimp/Kink/Ripple/Wave/Twist <input type="checkbox"/><br>Marks/Chatter <input type="checkbox"/><br>Mislabeled <input type="checkbox"/><br>Other/Details:                                                                           |                 |                                                                            |  | Contamination<br>Misaligned/off center <input type="checkbox"/><br>BOM/Route <input type="checkbox"/><br>Broken/Damage/Defect <input type="checkbox"/><br>Incomplete/Unclear Instructions <input type="checkbox"/><br>Drill Holes <input type="checkbox"/><br>Fit/Function <input type="checkbox"/> |  |                                      |  | Power Loss/Surge <input type="checkbox"/><br>Folio/Program <input type="checkbox"/><br>Grain Direction <input type="checkbox"/><br>Weld <input type="checkbox"/><br>Wrong Stock Pulled <input type="checkbox"/><br>Out of Sequence <input type="checkbox"/><br>Off-set/Set-up <input type="checkbox"/> |  |                                                 |  | Positioned Wrong <input type="checkbox"/><br>Outside Tolerance <input checked="" type="checkbox"/><br>Drawing <input type="checkbox"/><br>Finish <input type="checkbox"/><br>Part Lost/Missing <input type="checkbox"/><br>Misread <input type="checkbox"/> |  |  |  |